

Work Order ID 71968

Thursday, July 14, 2011 11:28:53 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: ✓

Date: 11-04-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DSI9470

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

8/11/29

for MLI 11-9-29

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14485

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 117628

11-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71968

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Item ID: D350-604-041

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Item Name: Rear Locker Extender

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Packaging

Receive & Inspect for Damage & Mat'l Certs
Packaging

0.00

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

Rec'd 7/28

130



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

Sublock

140



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

Rec'd 7/28

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Thursday, July 14, 2011 11:28:54 AM



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Item ID: D350-604-041

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Item Name: Rear Locker Extender

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8 work



Quality Control

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

w/a 1304
MF 11-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 11:28:58 AM

Page 1

Work Order ID: 71968

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender





Start Date: 7/14/2011

Required Date: 9/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: Q ☐ 03.12.01 ☐ Reformat ☐ KJ/RF ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6  Camlock Stud		Purchased	No			110	Each	83.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST357			83						
					117628		83						
D350-604-041P  Rear Locker Extender		Purchased	No			120	Each	0.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST010			14						
					67420		2						
					69592		12						
D2268  Decal		Manufactured	No			140	Each	14.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST010			14						
					67420		2						
					69592		12						
D2269  Decal		Manufactured	No			140	Each	11.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST010			11						
					67421		11						

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	40431
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
26/09/2011	23/08/2011	18460	Brigitte Golden		PO14485		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #3 Rear Locker Extender D350-604-041P B71968 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div>No. série B71968</div> <div>No. lot 35155</div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357





Date: Vendredi, 20/08-26 15:21:06
 Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
 Numéro Job : 35155
 Numéro Soumission : 3482
 Numéro B.A. :
 Cette fois : 2011-08-26 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : - - Type :
 Job précédente : 35154

Nom Dessin : REAR LOCKER EXTENDER
 Numéro Article : DKC134-0003
 Numéro Dessin : D350-604-041 & D2273
 Projet Numéro : DK-362
 Révision dessin : A & D
 Matériel : Derakane 470-36/411/510
 Date Dûe : 2011-09-02 Qté: 1 Udm: UNITE

Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Laminée Dart Aerospace: D2273
 N° de pièce Assemblage Dart Aerospace: D350-604-041

B 71968

Process Sheet Rév.: 03 Modifier la séq. 6 Prep-general.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 PRÉPARATION

Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: _____ Sceau: _____

2.0 AMB0350

Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-3/894-2

3.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)
 Catalyst N° DDM-9 N° de Lot: 1-27829-1

4.0 AC0747

Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 11-08-11 Sceau:

Date: Vendredi, 2011-08-26 15:21:06
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 35155

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003

Date: 21/09/11

Sceau:



7.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1

Date: 21/09/11

Sceau:



8.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total: 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-32245-1

9.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

10.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total: 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-31000-2

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total: 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-28728-1

12.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

- Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 35% Température: 75.2 Heure: 2:00 PM

Quantité: 1

Date: 21/09/11

Sceau:



Date: Vendredi, 2011-08-26 15:21:06
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 35155

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-32245-1

14.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27839-1

15.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité: 1

Date: 21 sept 11

Sceau: 7



16.0 DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1

Date: 23 sept 11

Sceau: 7



17.0 TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run: 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1

Date: 23 sept 11

Sceau: 7



18.0 AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-30872-1

19.0 AAC1101

N° 7775S, Dupont Activator Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total: 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2

Date: Vendredi, 2011-08-26 15:21:06
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 35155

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

20.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1

Date: 23-09-11

Sceau:



N° fiche de Mélange: N/A

21.0

AAC1607

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-31849-1

22.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-6687-1

23.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasker la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1

Date: 26-09-11

Sceau:



24.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 35155

N° de Fabrication: 26-09-11

Quantité: 1

Date: 26-09-11

Sceau:



25.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: Vendredi, 2011-08-26 15:21:06
L'utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 35155

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:



Description :

Quantité: 1

Date: 26 SEP. 11

Sceau:

bb

26.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.



Quantité: 1

Date: 26/9/11

Sceau: